

Date: Friday, 16/05/2008 8:45:37 AM
User: Julie Lecocq

Process Sheet

SPLIT

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING LUG
Job Number	: 39315		
Estimate Number	: 10255		
P.O. Number	:	Part Number	: D22301
This Issue	: 16/05/2008 S.O. No. :	Drawing Number	: D2230 REV F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: F
Previous Run	: 39137	Material	:
Written By	:	Due Date	: 30/05/2008
Checked & Approved By	: <i>JUD 08.5.16</i>	Qty:	<i>300</i> Um: Each
Comment	: Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0717 f(s)/Unit Total: 14.3430 f(s)

Lug Extrusion D2423 Extrusion

Batch: *B 33310*

C 208/05/20 (600)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut D2423 extrusion to 0.82"

Batch:

cut at Metec

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio D2230-1

(Check for crack while loading into the machine.)

2-Tumble and deburr rough edges after tumbling

Machine per drug D2230 Rev.F

C 208/05/20 (300)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Receive & inspect for visual damage Ensure C/C attached

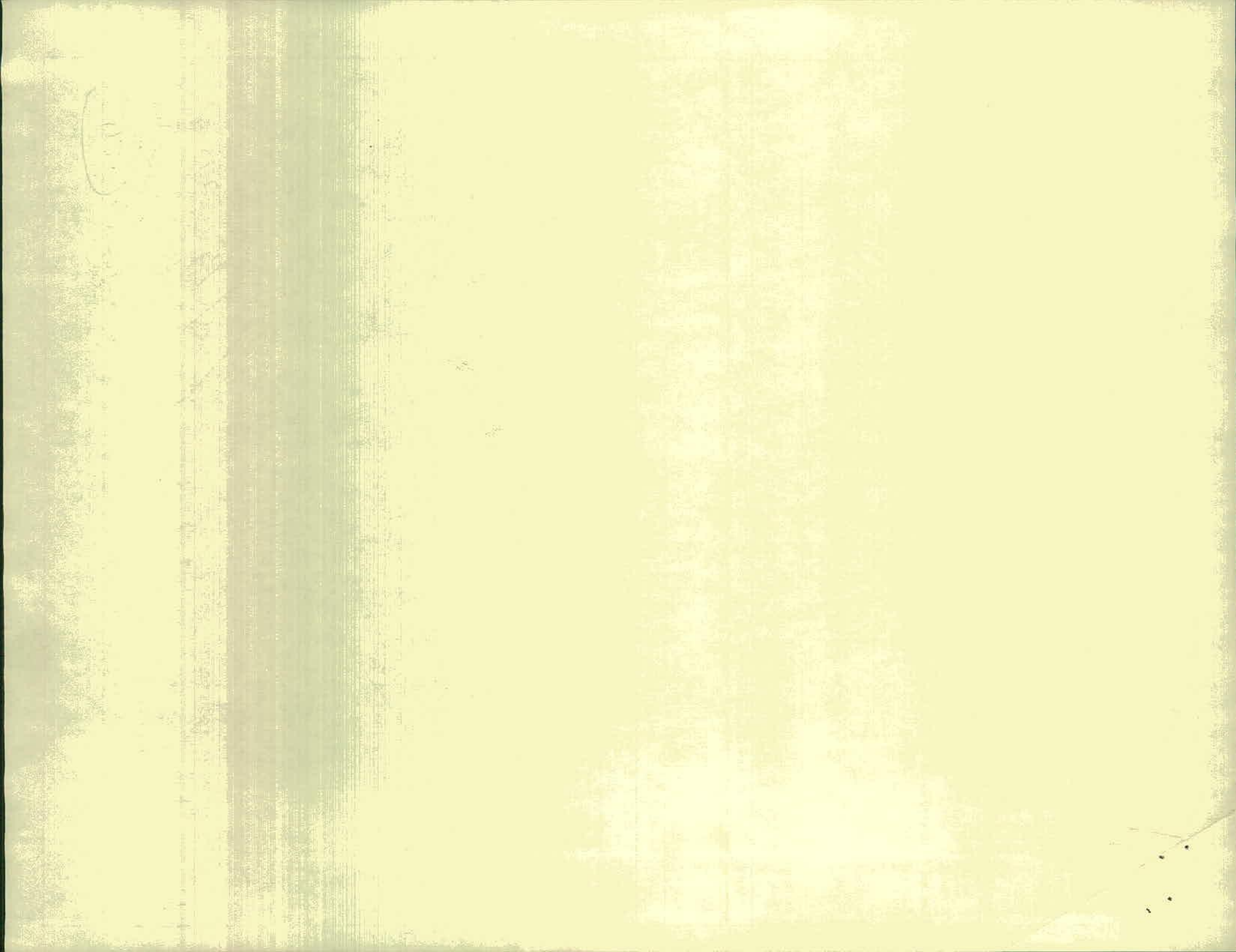
5.0	QC5	SECOND CHECK
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Comment: SECOND CHECK

Inspect level 5

5 08/06/09 (4215)



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Part Number: D22301

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L/2/12

08/06/10 (215)

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

center
5 08/06/10 (215)

8.0 POWDER COATING

POWDER COATING



M10 7925



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:15 PM
320
3:45 PM

2/12/M-L
08/06/11

(25)

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL *08/06/12* *(215)*

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

P 8/6/16 (215)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/16

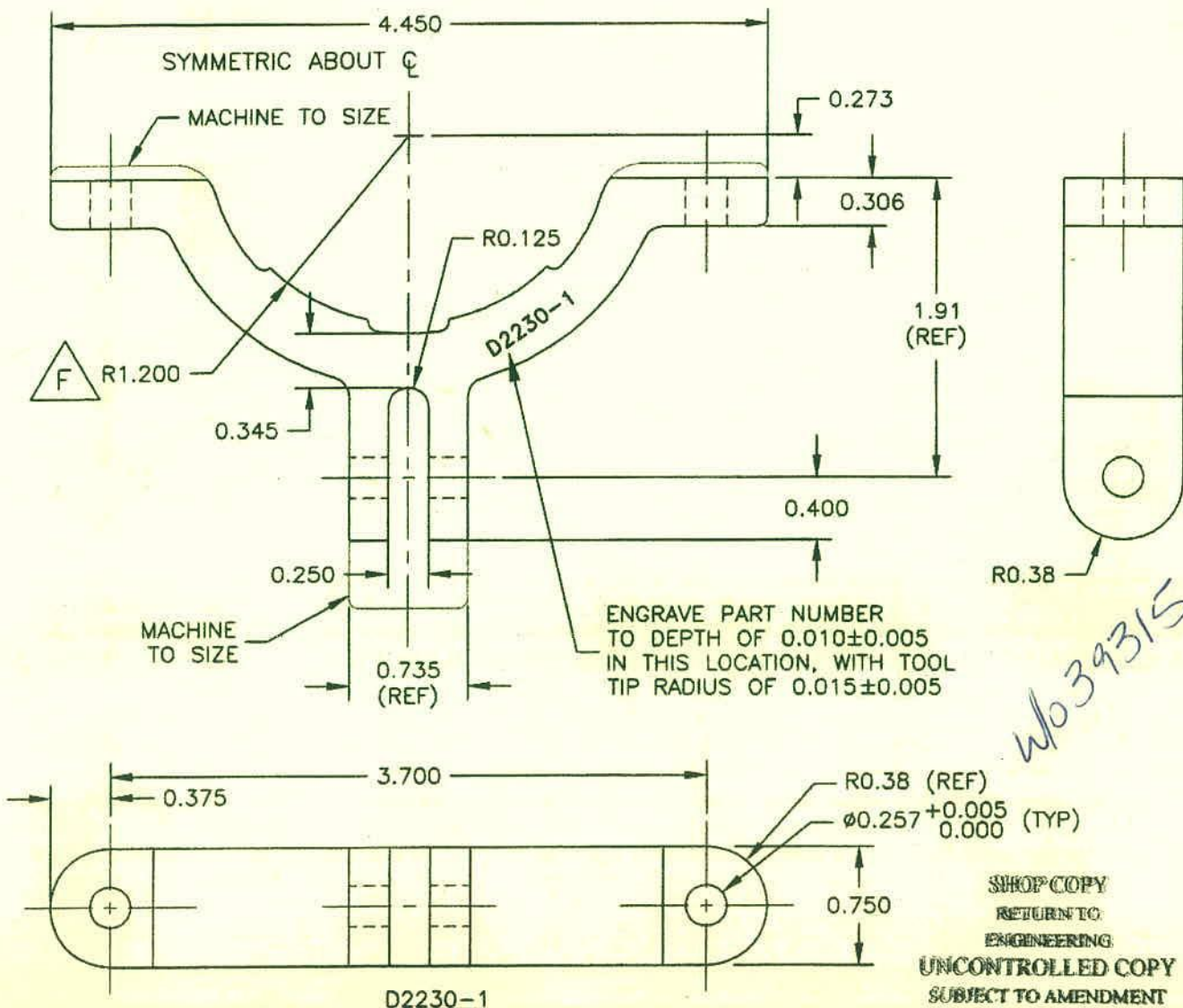
Job Completion



u 08.06.16

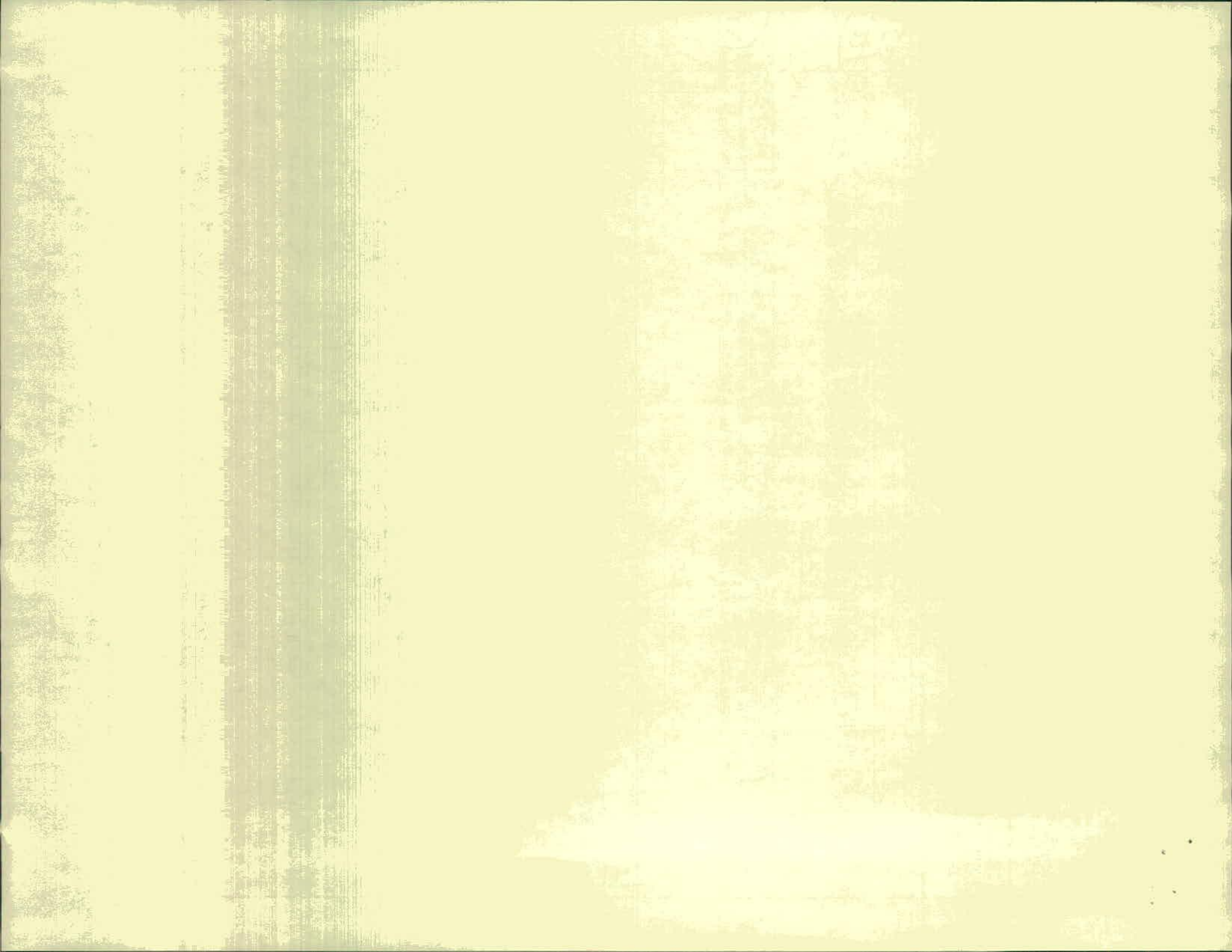
DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. F
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	SHEET 1 OF 2
				D2230	
DATE	99.12.13			TITLE	SCALE
				MOUNTING LUG	1:1
C	94.03.30	RE-DESIGN			
D	95.01.04	RE-DESIGN			
E	95.01.04	RE-DESIGN			
F	99.12.13	REDESIGN; R1.200 WAS R1.100			

RELEASED
99.12.21 DS

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

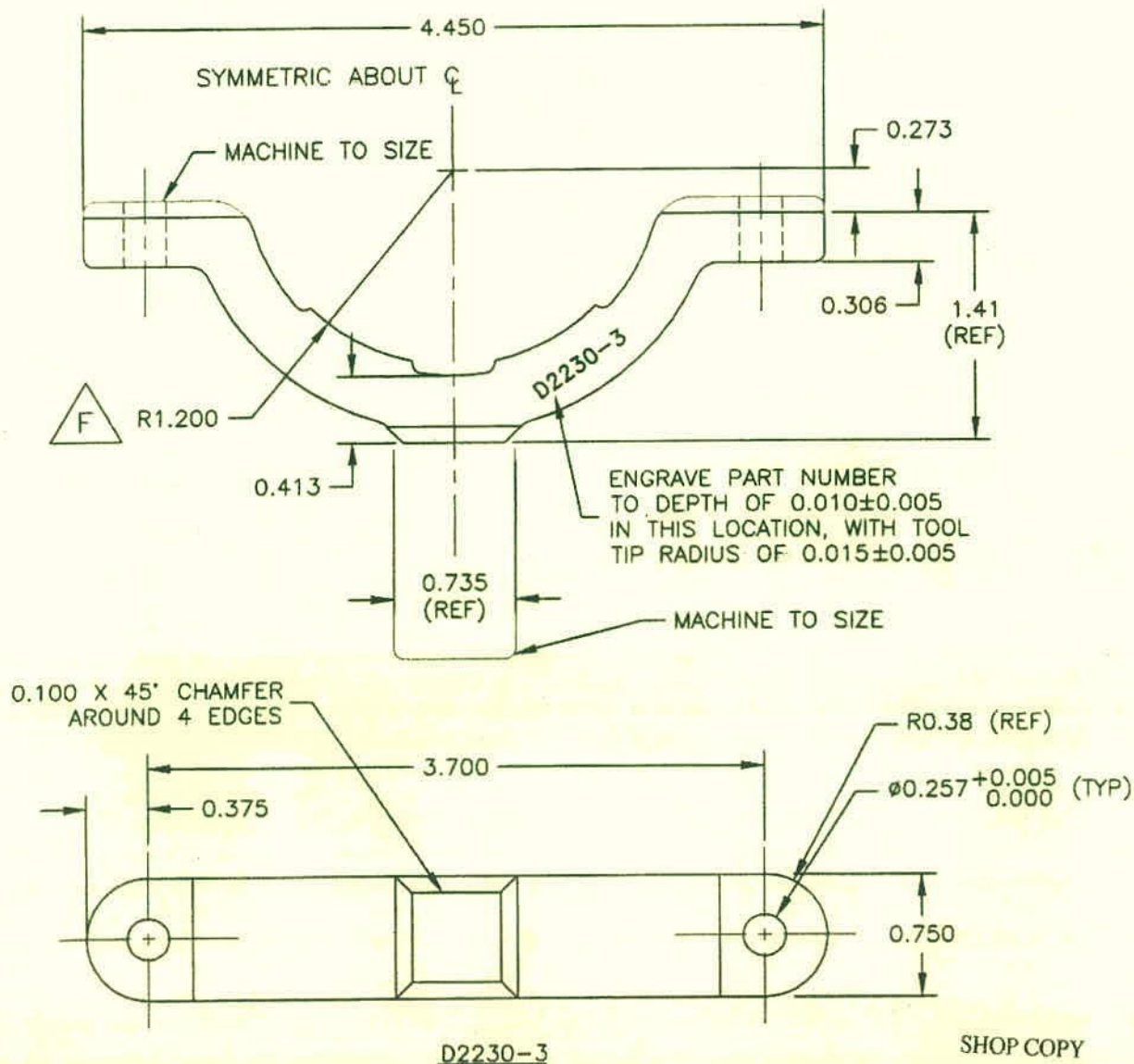
SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31315





DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39315

1880

1881

1882

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1887

1888

1889

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
215	D2230-1	Mounting Lug B39315	6387
	MATERIAL: supplied by DART D2423 B33310		

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.



Denise Robinson

Vankleek Hill, June 9, 2008

